FIG 1

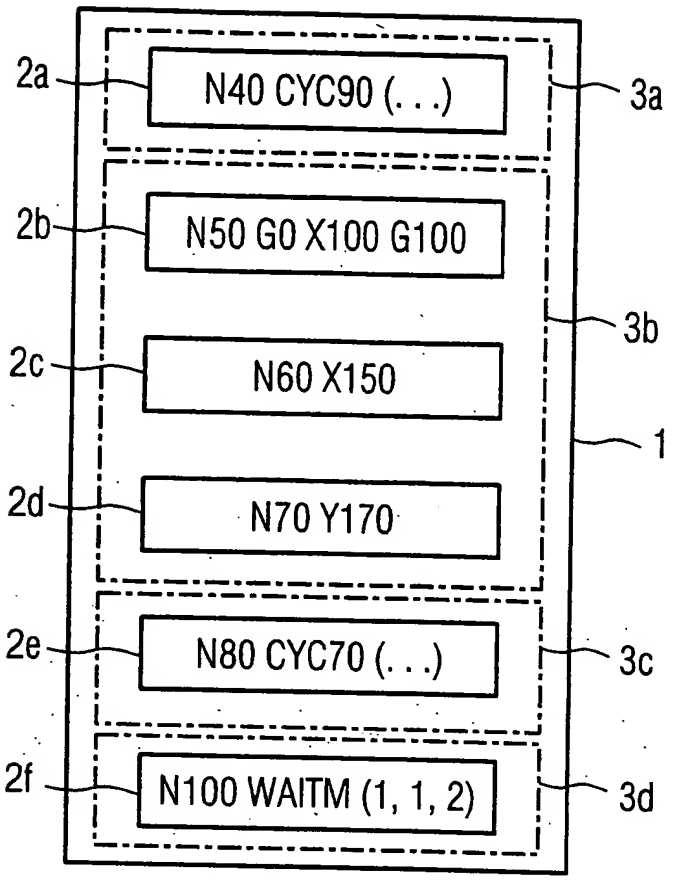

2a
N40 CYC90 (. . .)
3a
2b
N50 G0 X100 G100
3b
2c
N60 X150
1
2d
N70 Y170
2e
N80 CYC70 (. . .)
3c
2f
N100 WAITM (1, 1, 2)
3d

FIG 2

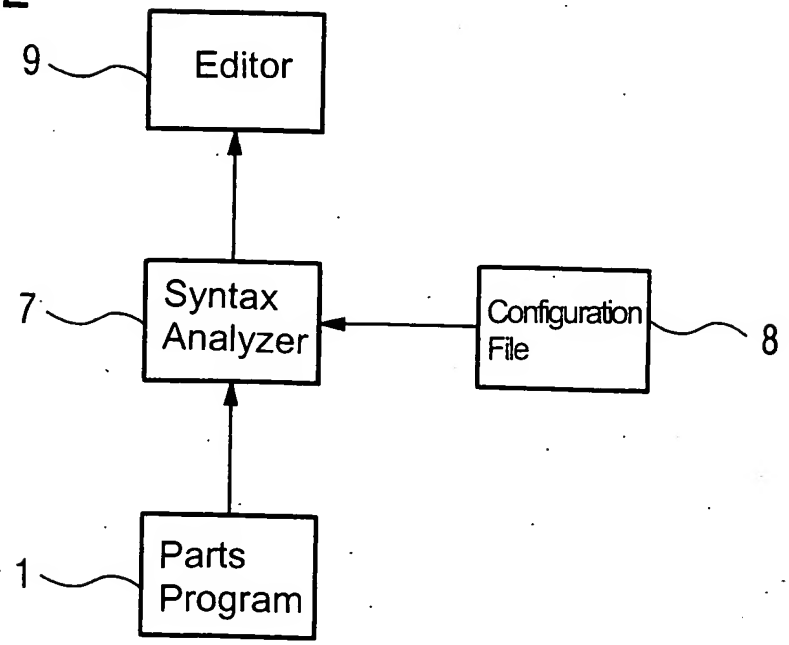

9
Editor
7
Syntax Analyzer
Configuration File
8
1
Parts Program

FIG 3

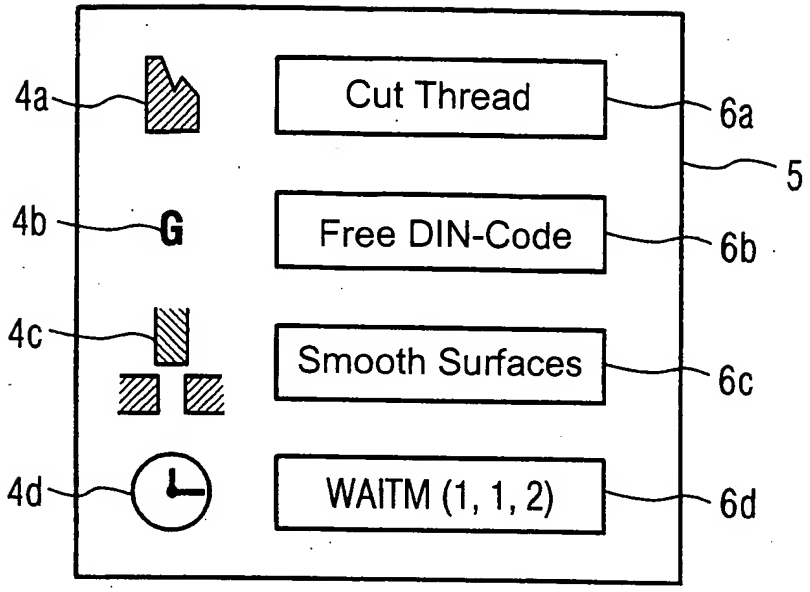
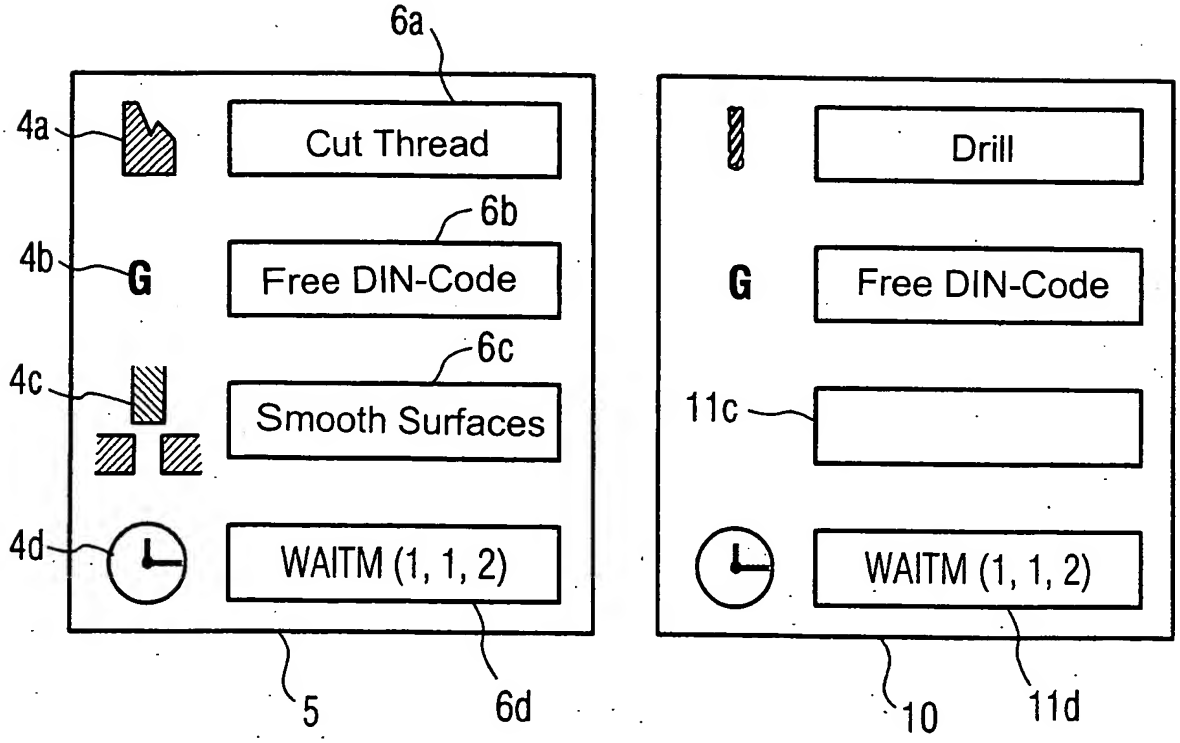

4a
Cut Thread
6a
5
4b
G
Free DIN-Code
6b
4c
Smooth Surfaces
6c
4d
WAITM (1, 1, 2)
6d

FIG 4


6a
4a
Cut Thread
6b
4b
G
Free DIN-Code
6c
4c
Smooth Surfaces
4d
WAITM (1, 1, 2)
5
6d
Drill
G
Free DIN-Code
11c
WAITM (1, 1, 2)
10
11d